· Work Order ID 100130

April-18-13 10:26:51 AM	-		*1()(1130*	11 1 x 11		. •		Page 1
Item ID: 646.3816 Revision ID: Item Name: Bracket Start Date: 4/18/13 Required Date: 5/02/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*	Accept	*N900 Cust Item I Customer:		೧ ೧*	Setup St	. IN	S1* S2*
QC:	Plan: MCゴ	Date: /3- 04- /			te:			op	R1* R2*
Sequence ID/ Work Center ID Draw Nbr	Operation Description Revision Nbr		Set Up/ Run Hours	Tool ID	Tool # Pla	an Accep ode Qty	pt Reject Qty		Insp
646.3800 110 *110* Mill Conv Conventional Milling Machine	N/C HAAS CNC VERTICAI Memo 1-Maçhine DWG REV:	oer DWG	0.00	Jash !	13/05/13	_ /2			
120 *120* QC	2- deburr an . QC2- Inspect parts off m Memo	d break all sharp edges achine FAI/FAIB	0.00	[] MSP 13/0	05/13	/2			

Quality Control

NCR: Y	Yes	/ No				WORK ORDER NON-	COL	NFORM	MANCE / UP[DATE			•
									0.2 6973		QA Closed:	Date:	
Work Orde	er:					DISPOSITION			·	AGAINST DE	PARTMENT	_	-,
Part N	-					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
NCR N	vo				 	work Order Opdate	_]		raige ran	Composite	1	Jupplier	<u>. </u>
Root Cause		Date	Step	Qty		ption of work order update or Non-conformance	1	nitial ief Eng	Act Descr	ion iption	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUL	T CATE	GORY			····	
Landir		Bending Centre No Cracks Crushed/O Cuffs Heat Trea nspection	Crimped t n Strip in Bend	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	ion Incomplete cions Incomplete/U enance eled d	Jnclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	-	Coraue W		Extrusio	, <u> </u>	Drawing		4	Calibration				

Out of Sequence

Outside Dimensions

Date:

DQA:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

SAO

· Work Order ID 100130

April-18-13 10:26:51 AM

100130 Item ID: 646.3810 Accept *N900040100* Setup Start **Revision ID:** Item Name: Bracket **Start Date:** 4/18/13 **Start Qty: 12.00** *12* Cust Item ID: Required Date: 5/02/13 Req'd Qty: 12.00 **Customer:** Reference: Run Start Process Plan: ____ Date: ____ Tooling: Approvals: Date: Stop Date:_____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject **Work Center ID** Description **Run Hours** Code Qty Qty Number 130 QC8- Inspect parts - second check 0.00 *130* 13/05/14 QC Memo 0.00 Quality Control 140 Outsource process-Anodize per QSI017 4.1.10.1 0.00 *140*

Outsource4 Outsource process - Anodize

Memo

Issue P/O: 19887 Black Anodize as per Dwg 646.3800

150

Receive & Inspect for Damage & Mat'l Certs

0.00

0.00

150

Packaging Packaging

Memo

0.00

Reject Insp. Stamp

CX 13,05/14 R

											DQA:	Date	•
NCR: Y	/es	/ No				WORK ORDER NON-O	CON	NFORN	MANCE / UPDATE		•		•
							*,**				QA Closed:	Date	
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İ	-		···			Use-as-is		Therm	oforming Fini	shing	Rec/Stor	e/Packaging	Other
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		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct _	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
		Heat Trea	t			Countersink		Mislabe	led		Positioned V	Vrong	
'		Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Memo

Quality Control

											DQA	ı: Da	ate:	
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						DISPOSITION	, i			AGAINST DE	PARTMEN	T/PROCESS		
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Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

0.00

Memo

QC

Quality Control

NCR: Y	'es / No				WORK ORDER NON-C	CONFOR	MANCE / UP	DATE	QA Closed:	 Date:	
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	Ripples in				Drill Holes	Offset			_	_	
	Torque W		xtrusio	, <u> </u>	Drawing	Out o	f Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish Folio

Picklist Print

* April-18-13 10:26:54 AM

Work Order ID: 100130

100130

Parent Item:

646.3810

646 3810

Parent Item Name: Bracket

Start Date: 4/18/13

Required Date: 5/02/13

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M7075T6A1.00X0.75X 0.125X0.060		Purchased	No			110	f	120.0000	0.1375	1.65				~~

*M7075T6A1 00X0 75X0 125X0 125X0

Location	Loc Qty	Loc Code
MAT036	120	
123947	120	

**

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORN	AANCE / UP	DATE			•
											QA Closed:	Date	
Work Ord	٥.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Ordi	er.					Rework	٦		Skid-tube	Crosstube	1	Water Jet	Engineering
Part I	No.					Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	No.					Work Order Update			Large Fab	Composite]	Supplier	
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Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
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	_	Bending				Bend	ļ	Grain		<u> </u>	Ovalized		Pressure/Forced
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		Cuffs			<u> </u>	Contamination	<u> </u>	Mainte		<u> </u>	Part Moved		
		Heat Trea				Countersink	-	Mislabe		-	Positioned		Tout.
	<u> </u>	Inspectio		Tube	<u> </u>	Cut Too Short	\vdash	Misread	i		Power Loss,	'Surge	Other
1	1	Ripples in	n Bend		1	Drill Holes	- 1	Offset					

Out of Calibration

Out of Sequence Outside Dimensions

Drawing

Finish

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

- χ^2 , MATERIAL! ALUMINUM 7075 1651 AMS-QQ A 250/12
- 2. FINISH. HARD ANODIZE IAW ME-A-8625 TYPE III. CLASS 2. COLOR BLACK: CARDINA: 4860-50 PRETREATMENT PRIMER PRIME IAW MILP 23377J TYPE I CLASS N
- 3. DEBURR AND BREAK ALL SHARP EDGES
- 4. IDENTIFY IAW MPP 120

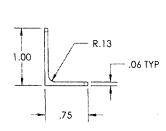
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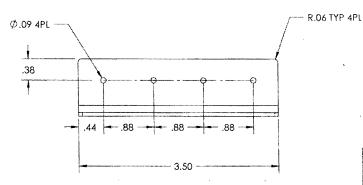
646.3810

Selection of the select

100130 MW

13-04-18





UNINCORPORATED Et(3)

03:647.

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	646 3814	WIPERBRA	CKET			
	646,3813	STRUT BRA	CKE			
	646.3512	GUSSET 81	RAÇKET			
	646.3811	RADIUS BI	ocr		Λ	/2
	646.3810	BRACKET				/2
QTY FINE	# PART#		DESCRIPTION		MATL	SPEC.
QIY			PARTS LIST			
NEXT ASSY (S) 646 4000	CANCAGE CANCAG	OS-19-CS CHECKEP #8PAVO	2608 TEMP	E HEIG	INDUST HTS DR. 92056-3512 17	
		C81 19-08 (()			ACKETS	
	DAMINSCHIS • FORFRANCIS • 2 PLACE DECA 3 PLACE DECA APPOLES 1 3	PE PUTUCHES PEL SALS ± DED	SCALE NON	5946 4< €	646.380 Lshi	1,70

DART AEROSPACE LTD	Work Order: 100 130
Description: Brackst	Part Number: 646, 38 10
Inspection Dwg: 646.3200 Rev: N/C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

3,50	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
$\begin{array}{c ccccccccccccccccccccccccccccccccccc$	3,50	-0,010	3,504	V		1111-04	vern
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R 0,06 = 0,010 0,062 V — Radius 6a		+ 0,010		/		111	
		+ 0,010		/			Radius Ga az
			ŕ				0
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Measured by:	MUPAN	Audited by:	J.A CAS	Preliminary Approval:	
Date:	13/05/13	Date:	13 05 14 3-8	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

\$ 10.04.15



A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62398

Date: 24-May-13

To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada

Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

Ph: 613-632-5200

		, ,	11: 613-632-5200	Fax: 613-632-1185			
Terms		Ship Via					
							
Quantity	Description						
1	Part: ASST		Rev:				
lot							
	20 PCS 646.3812 10 PCS 646.3717						
	20 PCS 646.3718						
	20 PCS 646.3719						
	10 PCS 646.3713 12 PCS 646.3714						
	25-PGS-646-3813						
	32 PCS 646.3810	,					
(LIADD ANODIZE DI 1 DI						
	HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2						
	PRIME MIL-P-23377J TYPE I CLA	SS N					
	6 PCS D4703-042						
	16 PCS D4726-1						
	BLACK ANODIZE						
	MIL-A-8625 TYPE II CLASS 2 Job: 20130308	DO 4000=					
	300. 20130308	PO: 19887	Line:				
	Certificate of Conformance						
	A.T.G. Industries certifies that all items in this shipment are in conformance						
	with all requirements, specifications and	d drawings referenced i	n the purchase order.				
	ISO 9001 : 2008 RE	GISTERED					
	ATG SALES-2010 TE	ERMS APPLY					
	DATE: 24/5/13						
	CERTIFIED SIGNATURE :	•					
	Section 125 Grown order.						
	RECEIVER SIGNATURE :						
	NEOLIVER OIGNATORE .						
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